

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008955**Date Inspected:** 10-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

North Tower Lift 1

This QA Inspector performed random MT on the butter ends stiffeners in the North Tower Lift 1 previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector observed one indication at the time of testing.

1. 7th Stiffener on Skin E

This QA Inspector observed an indication in the above noted weld accepted by ZPMC QC MT personal. This QA Inspector issued an incident report on the above noted MT rejection.

2AE

SMAW welding of weld joint 001 located on SEG008B.

Welder is identified as Mr. Hu Yanming (062092). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair and

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

repair procedure B-WR7457.

SMAW welding of weld joint 002 located on SEG008C.

Welder is identified as Mr. Hu Yanming (062092). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair and repair procedure B-WR7457.

1AW

FCAW welding of weld joint 153 located on SSD34A-P.P8.5.

Welder is identified as Mr. Qie Jianzhou (045280). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-FCM-Repair and repair procedures B-CWR635.

5BE & 5CE

FCAW welding of weld joint 006 located on OBE5.

Welder is identified as Mr. Li Shuqiang (053609). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

1AW & 1AAE

SMAW welding (repair) on side plate stiffeners on panel point 8.5 at counter weight side of segment.

Welder is identified as Mr. Li Guangzu (069493). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair.

5CE

This QA Inspector observed heat straightening in progress on cantilever BK1-018 at PP 33 by ZPMC. Heat straightening was performed per HSR1 (B)-7593 procedure.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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